

5/44

6

DART AEROSPACE LTD		Work Order:	24533
Description: Hi-Step Leg Assembly		Part Number:	D2582
Dwg: D2582 Rev. A; D2322 Rev. C; D2279 Rev. D		Qty:	8 YQ
			Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller (minimum lots of 500s) <i>PF 02.10.22</i>	<i>JL</i>	<i>05.10.12</i>	10
2	MV	Cut blanks: (6.520" x 4.500") +/- 0.010" (grain along 4.500") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2322			
3	MV	Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50") Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279	<i>J.L</i>	<i>05.10.25</i>	10
4	MV	Cut blanks: (16.61" x 8.51") +.000/-0.020" (grain along 8.51") for each leg Material: 5052-H32 sheet (QQ-A-250/8) 0.080" Thick (M5052H32S.080) Identify as D2278 (Note: make two legs per assembly)	<i>J.L</i>	<i>05.10.25</i>	10
5	MV	Cut blank: (3.400") +/- 0.020" Material: 6061-T6 (QQ-A-250/8) 0.25" Thick (M6061T6B0.250x1.000) Identify as D2280 (Note: make two spacers per assembly)	<i>J.L</i>	<i>05.10.25</i>	20
6	MV	Machine as per folio D2322, use stack of 15	<i>J.L</i>	<i>05.10.25</i>	10
7	MV	Deburr to take measurement	<i>J.L</i>	<i>05.10.25</i>	10
8	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	<i>05.10.25</i>	10
9	QC8	Second inspection	<i>J.L</i>	<i>05.10.25</i>	10
10	MV	Machine as per folio D2279, use stack of 15	<i>J.L</i>	<i>05.10.26</i>	10
11	MV	Deburr to take measurement	<i>J.L</i>	<i>05.10.25</i>	10
12	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	<i>05.10.25</i>	10
13	QC8	Second inspection	<i>J.L</i>	<i>05.10.25</i>	10
14	MV	Machine as per folio D2278, use stack of 10	<i>J.L</i>	<i>05.10.26</i>	10
15	MV	Deburr to take measurement	<i>J.L</i>	<i>05.10.26</i>	20
16	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	<i>05.10.26</i>	20
17	QC8	Second inspection	<i>J.L</i>	<i>05.10.26</i>	20
18	MV	Machine per folio D2280 and Dwg D2280	<i>J.L</i>	<i>05.10.26</i>	20
19	QC2	Inspect parts as they come off the CNC machine	<i>J.L</i>	<i>05.10.25</i>	20
20	MV	Tumble. Deburr any rough edges after tumbling.	<i>J.L</i>	<i>05.10.25</i>	20

RELEASED  
02/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05.10.26	6	1 part in stack of 10 holes did not go thru	<i>AB</i>	- scrap & replace	J.L 05.10.26	<i>AB</i> 05.10.26	<i>AB</i> 05.10.26	<i>AB</i> 05.10.26
05.11.21	23	2 D 2322 were out of tolerance 1 D 2379 was out of tolerance 1 D 2279 crack.	<i>AB</i> <i>AB/12</i>	Scrap & destroy		<i>AB</i> 05.11.21	<i>AB</i> 05.11.21	<i>AB</i> 05.11.21

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 05/11/22

NOTE: Date &amp; initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD		Work Order:	24533
Description: Hi-Step Leg Assembly		Part Number:	D2582
Dwg: D2582 Rev. A; D2322 Rev. C; D2279 Rev. D		Qty:	10
			Page 2 of 2

Step	Location	Procedure	By	Date	Qty
21	QC8	Second inspection	ED	05/10/21	20
22	GA	Deburr D2322, D2279 and D2278 stack	FF	05/11/21	20
23	GB	Bend D2322 and D2279 per Dwg D2322 and D2279	SB	05/11/21	8
24	QC5	Inspect work to Step 23	AB	05/11/21	8
25	FP	Chemical conversion as per QSI 005 D2278, D2279, D2280, D2322	SB	05/11/21	8
26	GA	Assemble as per Dwg D2582 and <b>Identify as D2582 Assembly</b>			
		Qty Part Number Description Batch			
		2 D2278 Leg B24533			
		1 D2279 Spacer B24533			
		2 D2280 Spacer B24533			
		1 D2322 Spacer B24533			
		22 MS20470AD4-4 Rivet M18729			
		4 MS20470AD4-5 Rivet M16163			
27	QC5	Inspect work to Step 26	AB	05/11/21	8
28	GA	Identify and Stock	SB	05/11/21	8
29	AC	Cost / part 40.15	SAC	05/11/22	8
30	DC	Close W/O 40.15 Inspect Level 21	DC	05/11/22	8

Rev	Date	Change	Revised By	Approved
A	96.07.08	New Issue		
B	99.02.10	Re-format	DM	
C	01.10.16	Added new rivet and new dwg (mpp2165)	SM	
D	02.05.14	Added rivet option	NG	
E	02.10.07	Re-format; Incorporated D2278, D2279, D2280, D2322	KJ RF	SA

RELEASED  
02/10/22 FF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr				

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	24533
Description: Leg	Part Number:	D2278
Inspection Dwg: D2278	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

Measured by:	J.L	Audited by:	gm	Prototype Approval:	N/A
Date:	05-10-26	Date:	05/10/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	<i>[Signature]</i>

H:\FORMS\Quality Assurance\approved QA\FAI revD

RELEASER  
1101-1012

DART AEROSPACE LTD	Work Order:	24533
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	J.L	Audited by:	gml	Prototype Approval:	N/A
Date:	05/10/25	Date:	05/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

RELEASED  
10/10/13

DART AEROSPACE LTD	Work Order:	24533
Description: Spacer	Part Number:	D2280
Inspection Dwg: D2280	Rev: C1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	J.L	Audited by:	9ml	Prototype Approval:	N/A
Date:	05/10/25	Date:	05/10/25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue P/O D2582	KJ/JLM	

RELEASER  
11/04/1013

DART AEROSPACE LTD	Work Order:	24533
Description: Step Spacer	Part Number:	D2322
Inspection Dwg: D2322	Rev: C	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	J.L	Audited by:	E.P	Prototype Approval:	N/A
Date:	05.10.25	Date:	05/10/25	Date:	N/A

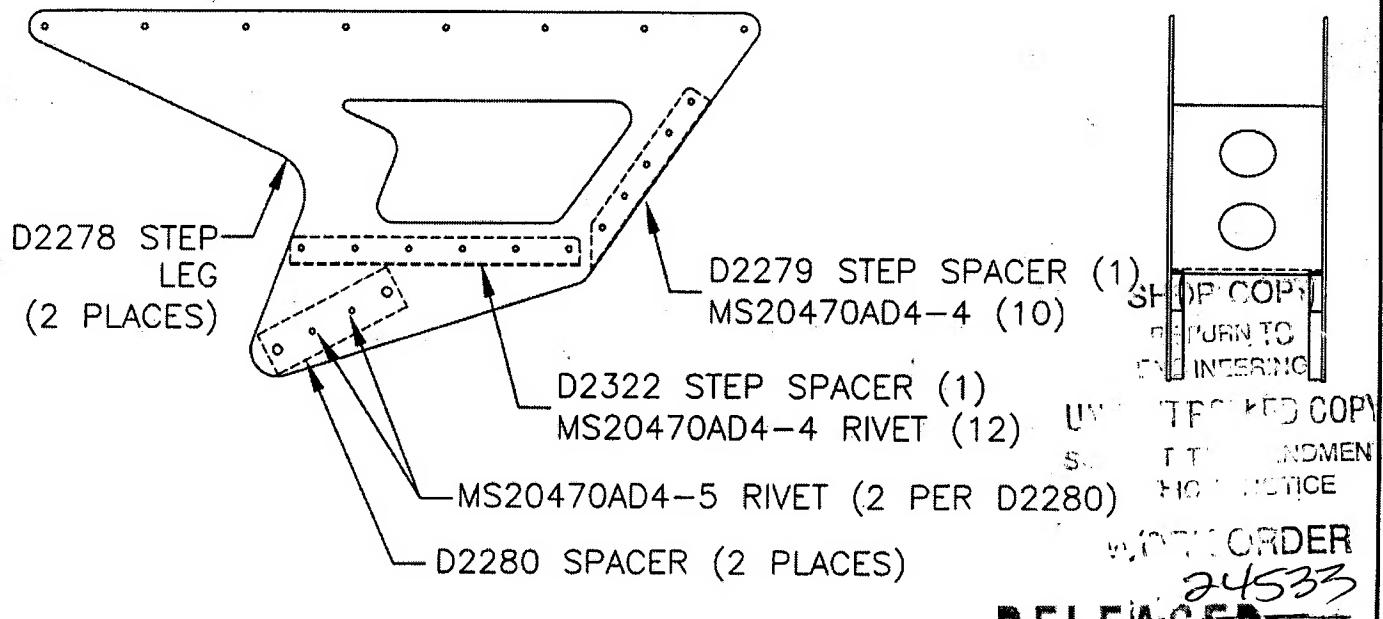
Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM

RE-RELEASED  
11/04/10/12

**DART**GACCO  
PRINTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2582
DATE		REV. A SHEET 1 OF 1
01.10.05		TITLE STEP LEG ASSEMBLY
A	01.10.05	SCALE 1:5 NEW ISSUE

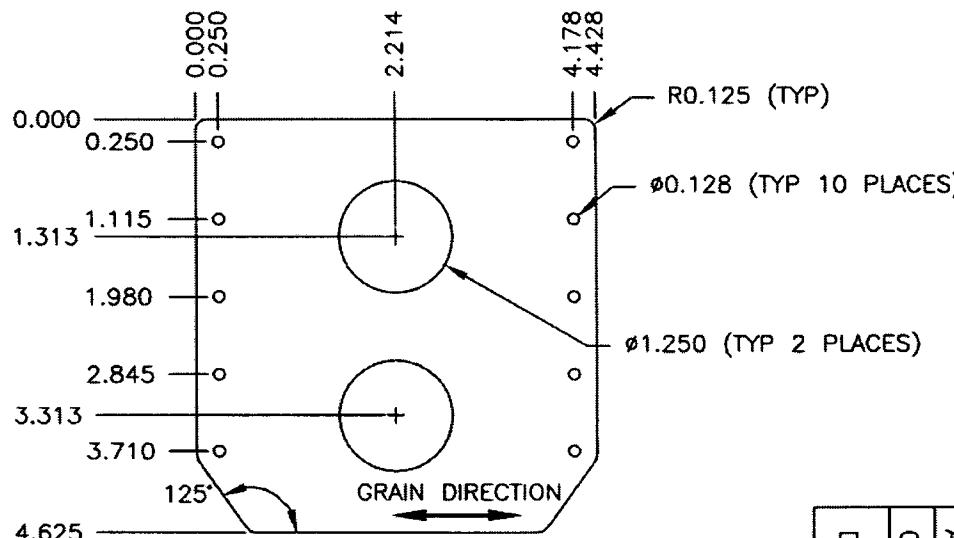
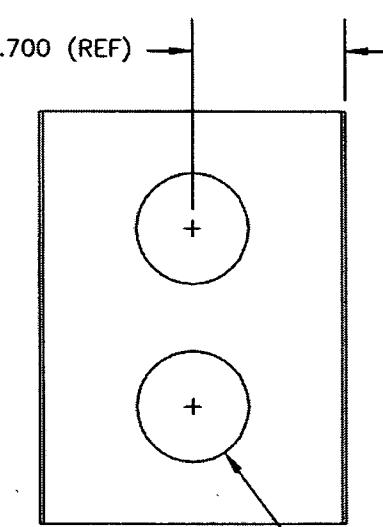
QTY	PART NUMBER	DESCRIPTION
2	D2278	STEP LEG
1	D2279	STEP SPACER
2	D2280	SPACER
1	D2322	STEP SPACER
22	MS20470AD4-4	RIVET
4	MS20470AD4-5	RIVET

D2582

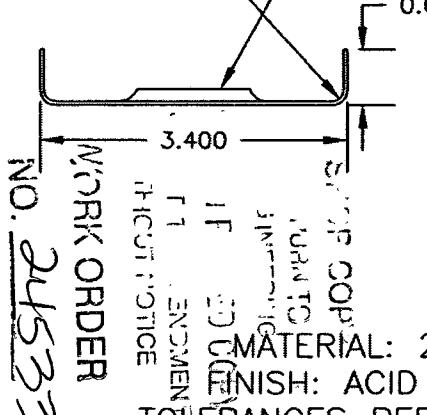


**DART**

DESIGN B/W	DRAWN BY <i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>RE</i>	APPROVED <i>MM</i>	DRAWING NO. D2279
DATE 98.10.05	STEP SPACER	SCALE 1:2
A 94.10.13	NEW ISSUE	SHEET 1 OF 1
C 94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	REV. D
D 98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

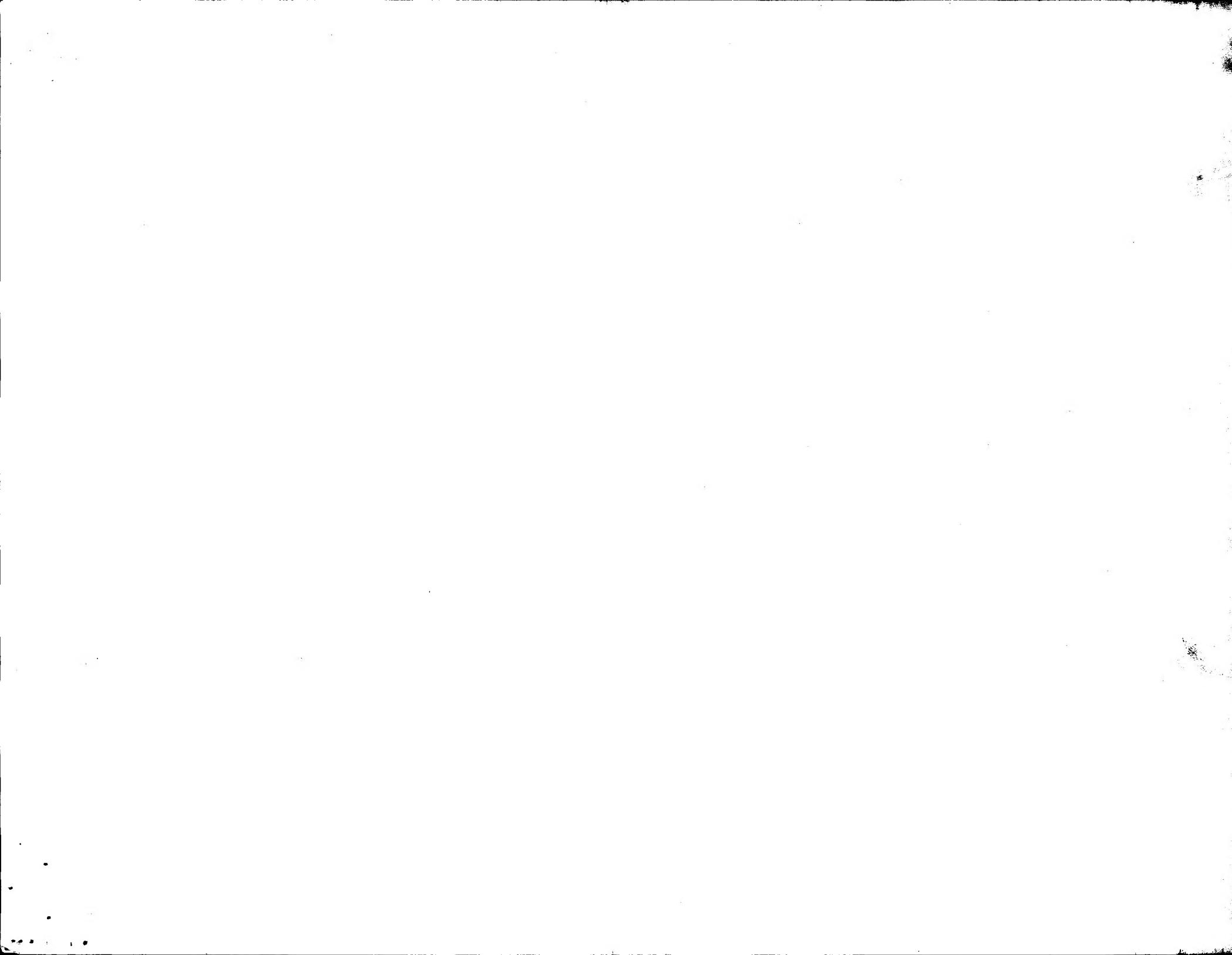
FLAT LAYOUT

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)



WORK ORDER  
NO. 24533

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED



## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyOct 11, 2005  
11:50 am

Work Order No. : 0024533  
 Project Name : D2582  
 Project For : WK544  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D2582  
 Description : Hi-Skid Step Leg Ass'y  
 Manufactured : Yes  
 Amount Req'd : 10  
 Amount Done : 0  
 Start Date : 10-11-05  
 Est Finish Date : 11-05-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00	0.00	0.00
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00	0.00	0.00
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Burden :	0.00	0.00	0.00	0.00	0.00
===== ===== =====					
Total Cost :	0.00	0.00	0.00	0.00	0.00
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED	APPROVED	DRAWING NO. D2280	SHEET 1 OF 1
DATE		TITLE	SCALE
98.09.29		SPACER	1:1
A	94.10.14	NEW ISSUE	
B	95.03.22	MATERIAL CHANGE, 0.15 WAS 0.20	
C	98.09.29	0.188 DIA HOLE CHANGED TO 0.213	
	01-10-05	ADD C/SINK & KNUURLING	

RELEASED  
RESTD/CS KE

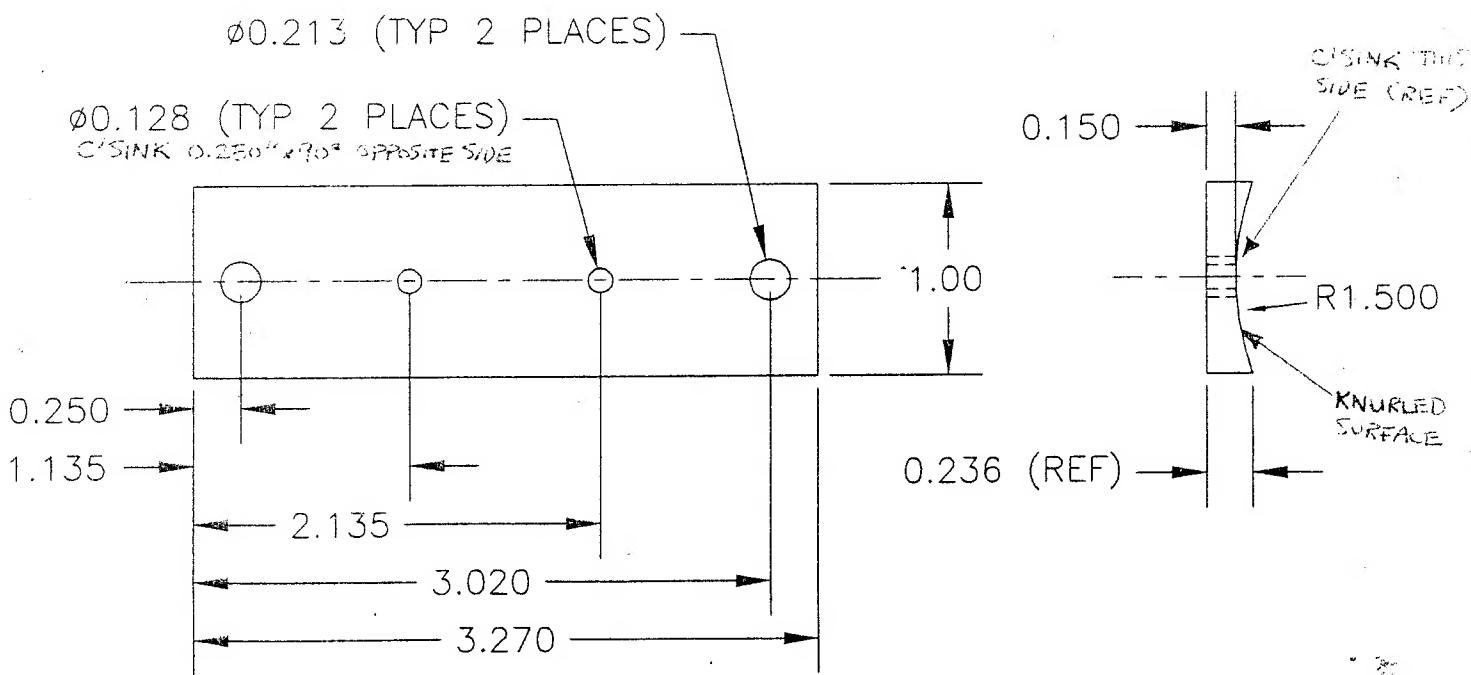
CP

UNDER REVIEW

9.03.15 CP

DESIGN OK, BUT CHECK WITH  
DB BEFORE MANUFACTURE

CONTROLLED COPY



MATERIAL: 6061-T6 (QQ-A-200/8) 0.25 x 1.00

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

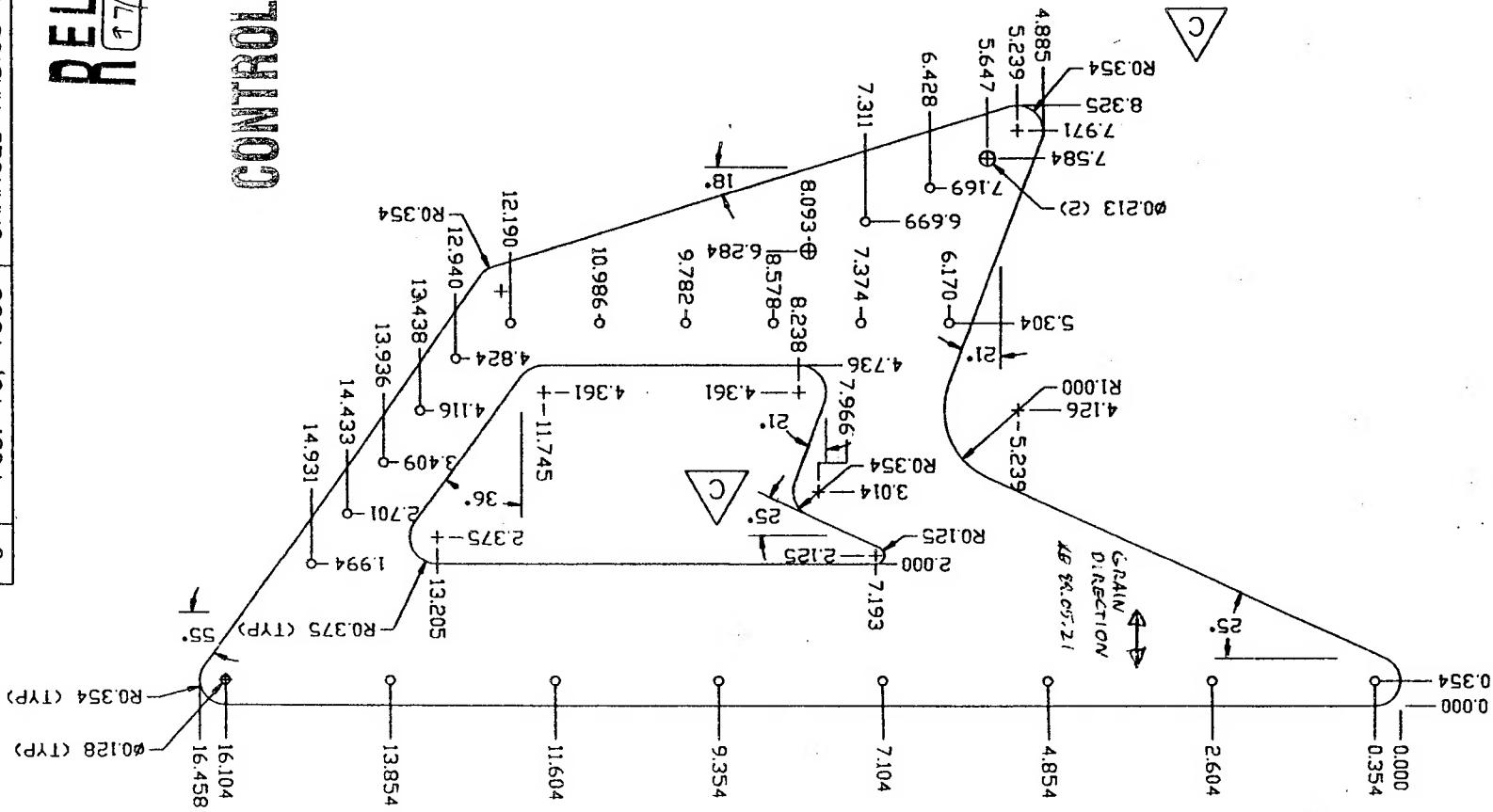
B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHEFED	APPROVED	D2278	REV. C SHEET 1 OF 1
DATE	Oct. 13, 1994	TITLE	SCALE
C	Feb. 16, 1995	LEG	1:2.5
		CHANGED RADIUS TO 0.354	

## DART

RELEASED  
17/01/27 BJD

CONTROLLED COPY

MATERIAL: 5052-H34 0.080 THICK



DEGEN OK, BUT CHALK OUT

100-215 20

## UNDER REVIEW